

What is claimed is:

1. A method of laser welding a plurality of coated metal sheets comprising the steps of:

providing coated sheets of metal having opposing first and second surfaces;

creating a raised region on at least one of the coated sheets, the raised region formed on the first surface and wherein the second surface remains continuous and uninterrupted;

applying a laser beam forming a laser weld wherein gases produced during the forming of the laser weld escape via the at least one embossment.

2. The method of laser welding a plurality of coated metal sheets according to Claim 1 wherein the step of creating a raised region comprises punching at least one embossment on at least one coated metal sheet, the embossment comprising a depression having a raised peripheral edge.

3. The method of laser welding a plurality of coated metal sheets according to Claim 1 wherein the step of creating a raised region comprises applying fine particles between the plurality of coated metal sheets.